

Date: Monday, 2/11/2008 2:12:25 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	FLOAT WEB		
Job Number	37344		Part Number	D3289041		
Estimate Number	10792		Drawing Number	D3289 REV D		
P.O. Number	:		Project Number	N/A		
This Issue	2/11/2008	S.O. No. :	Drawing Revision	D		
Prsht Rev.	NC		Material	:		
First Issue	././	Type : LANDING GEAR	Due Date	2/25/2008	Qty:	4
Previous Run	36187		Um:	Each		
Written By	:					
Checked & Approved By	KJ 08/02/11					
Comment	Est Rev:A 04.09.28 New Issue KJ/JLM Est Rev:B 07-09-09 As per Rev C JLM Verified By:EC Est Rev:C 07-12-06 as per Rev D DD					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion 'I Beam' thin
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) <span style="margin-left: 100px;">④</span> Pick: Qty Part Number Description Batch 1 D2600-5-108 Web <u>29985</u> <u>SL 8-2-20</u>		
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 1-Cut D2600-5-108 to as per Dwg D3289 2-Transfer drill web from D3283-3 doublers 3-Drill web using DT 8748 as per Dwg D3289 4-Using uni-bit, open holes as per Dwg D3289 5-Deburr holes and ends <span style="margin-left: 100px;">SL 8-2-20</span>		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP <u>RF 08/02/25</u>		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <span style="margin-left: 100px;">SL 8-2-26</span>		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/03/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FLOAT WEB
Job Number: 37344		Part Number: D3289041
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	QC3	INSPECT POWDER,COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		5 08/03/03 (44)
6.0	D32833	Doubler 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)		(6)
Pick: Qty Part Number Description Batch		
2 D3283-3 Doubler 26193 SL 8-2-75		
7.0	MS20470AD47	Rivet, Universal Head 
Comment: Qty.: 85.0000 Each(s)/Unit Total : 340.0000 Each(s)		(P+G)
Pick: Qty Part Number Description Batch		
85 MS20470AD4-7 Rivet m 105 940 (347) M 8-2-27		
8.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1 
Comment: LANDING GEAR RESOURCE 1		
1- Apply LPS between doublers and web as per dwg D3289 2- Coat rivets with LPS 3- Rivet doublers as per dwg D3289		
A/R	LPS-3	Batch: M 104929 (4)
9.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		5 08/03/03 (44)
10.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: LG		(4)
11.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		P 08/03/04 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8-2-27	7.0	1 rivet had to be removed and the hole slightly became slightly oversized  R.C Human error	Initial QSCM2	Replace rivet Qty 1 With M5 20470 ADS-7 M 2655	8-2-27	Initial 8-2-27	Initial 8-2-27	Initial 8-2-27

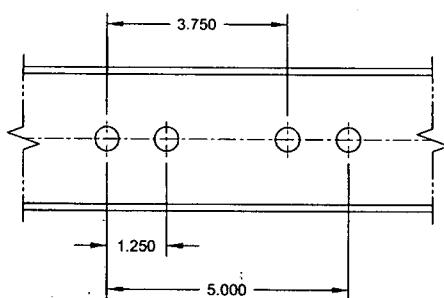
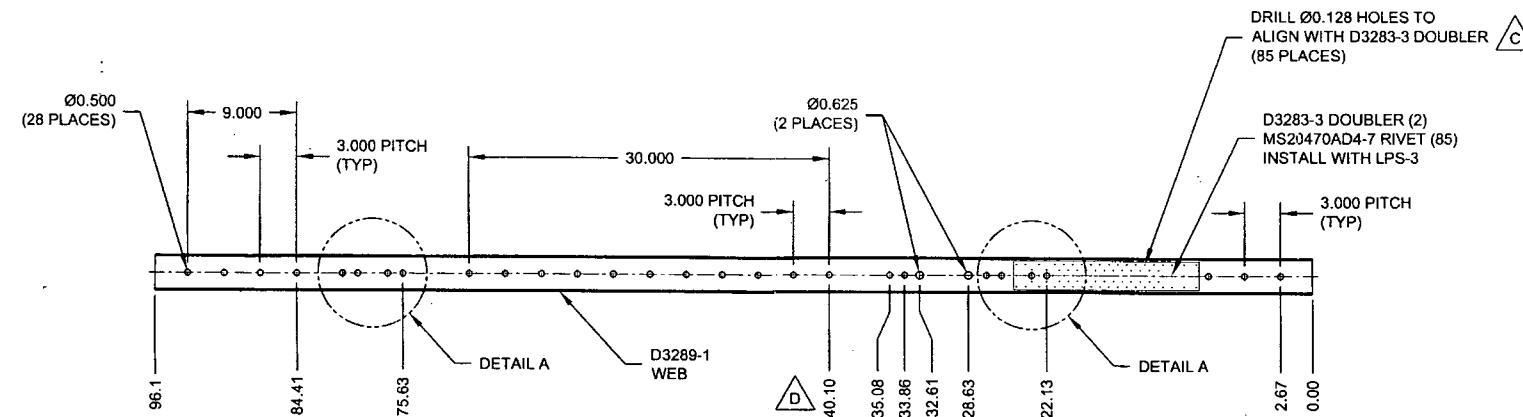
NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DETAIL A**  
(RIVET HOLES NOT SHOWN)  
SCALE 1:5

Qty -041	Part Number	Description
X	D3289-041	FLOAT WEB
1	D2600-5-108	EXTRUSION
2	D3283-3	DOUBLER
85	MS20470AD4-7	RIVET

**NOTES:**

- 1) MATERIAL: MAKE FROM D2600-5-108 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-3 DOUBLERS AND D3289-1 WEB. INSTALL RIVETS COATED IN LPS LABORATORIES LPS-3
- 7) WEIGHT: 5.00 lbs

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 3734

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D	MID-FLOAT HOLES ON D3288 WERE MOVED 2.00" FWD & ROTATED INBOARD & OUTBOARD BY 17" DUE TO GHW INTERFERENCE. THEREFORE, 40.10 WAS 38.10.	MB	07.09.14
C	CORRECTED TYPO (-3 WAS -1)	MB	07.06.04
B	ADD HOLES FOR OEM COMPATIBILITY	CP	05.03.16
A	NEW ISSUE	CP	04.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>99</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>14</i>	DRAWING NO.	REV. D
CHECKED	<i>2014</i>	D3289	SHEET 1 OF 1
MFG. APPR.	<i>EC</i>	TITLE	SCALE
APPROVED	<i>WJ</i>	FLOAT WEB, 206A/B	
DE APPR.	<i> </i>	1:10	
DATE	07.09.14	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	

